

Work Order ID 87313

July-13-12 11:51:09 AM

\*87313\*

Page 1

Item ID: D4419-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Support Plate

Start Date: 7/10/12 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 8/17/12 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/07/13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4419	A

100 0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

304.128

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

8 0 Jm 12-7-21

8 0 Jm 12-7-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 87313

**\*87313\***

Page 2

July-13-12 11:51:09 AM

Item ID: D4419-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Support Plate  
 Start Date: 7/10/12 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 8/17/12 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	SMB 12-7-23	DAS 16 7/6/12		8			
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location:  Memo	0.00 0.00	ST 1/2			8x			SD 12-7-23
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							12/7/24 MR 12-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July-13-12 11:51:09 AM

Page 1

Work Order ID: 87313

Parent Item: D4419-3

Start Date: 7/10/12

Required Date: 8/17/12

Parent Item Name: Aft Support Plate

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA

Purchased

No

sf

25.4260

2.9103158

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

25.426

121380

13.6

121780

11.826

121380

Sm 12-7-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>87313</b>
<b>Description: Aft Support Plate</b>		<b>Part Number:</b>	<b>D4419-3</b>
<b>Inspection Dwg: D4419</b>	<b>Rev: A</b>	<b>Page 1 of 2</b>	

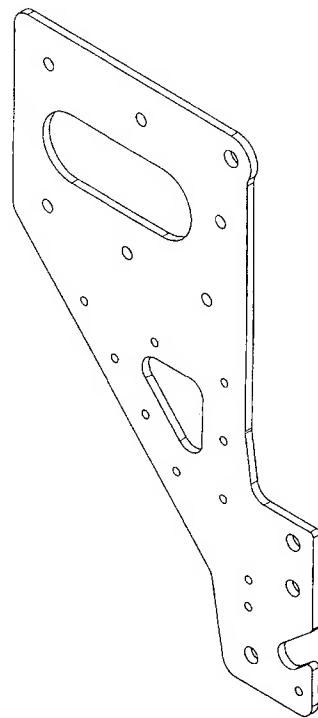
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130"	✓		✓	mmol
Ø0.191	+0.005/-0.001	0.191"	✓		✓	"
Ø0.250	+0.005/-0.001	0.250"	✓		✓	"
Ø0.53	+0.008/-0.001	0.530"	✓		✓	"
5.55	+/-0.030	5.562"	✓		✓	"
5.27	+/-0.030	5.281"	✓		✓	"
4.25	+/-0.030	5.267"	✓		✓	"
2.80	+/-0.030	2.793"	✓		✓	"
0.40	+/-0.030	0.406"	✓		✓	"
3.83	+/-0.030	3.833"	✓		✓	"
5.56	+/-0.030	5.578"	✓		✓	"
6.26	+/-0.030	6.273"	✓		✓	"
7.14	+/-0.030	7.151"	✓		✓	"
7.73	+/-0.030	7.737"	✓		✓	"
0.31	+/-0.030	0.316"	✓		✓	"
0.38	+/-0.030	0.385"	✓		✓	"
0.750	+/-0.010	0.754"	✓		✓	"
1.53	+/-0.030	1.539"	✓		✓	"
0.390	+/-0.010	0.386"	✓		✓	"
0.450	+/-0.010	0.457"	✓		✓	"
1.67	+/-0.030	1.675"	✓		✓	"
10.55	+/-0.030	10.557"	✓		✓	Producers
8.00	+/-0.030	8.005"	✓		✓	mmol
6.02	+/-0.030	6.024"	✓		✓	"
1.10	+/-0.030	1.093"	✓		✓	"
1.20	+/-0.030	1.212"	✓		✓	"
0.50	+/-0.030	0.495"	✓		✓	"
1.500	+/-0.010	1.505"	✓		✓	"
0.60	+/-0.030	0.610"	✓		✓	"
2.300	+/-0.010	2.307"	✓		✓	"
0.63	+/-0.030	0.641"	✓		✓	"
0.991	+/-0.010	0.995"	✓		✓	"
0.440	+/-0.010	0.446"	✓		✓	"

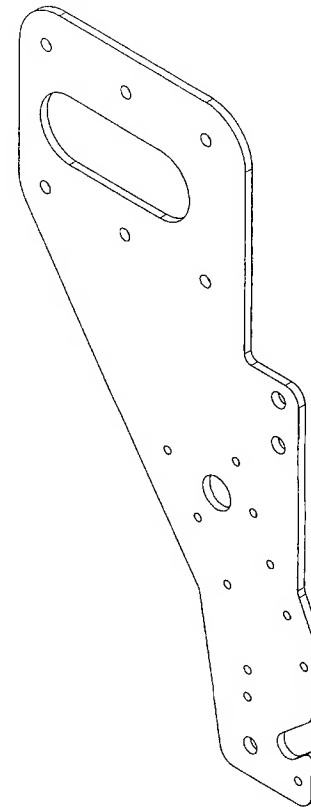
D/ 10







**D4419-1 FWD SUPPORT PLATE**



**D4419-3 AFT SUPPORT PLATE**

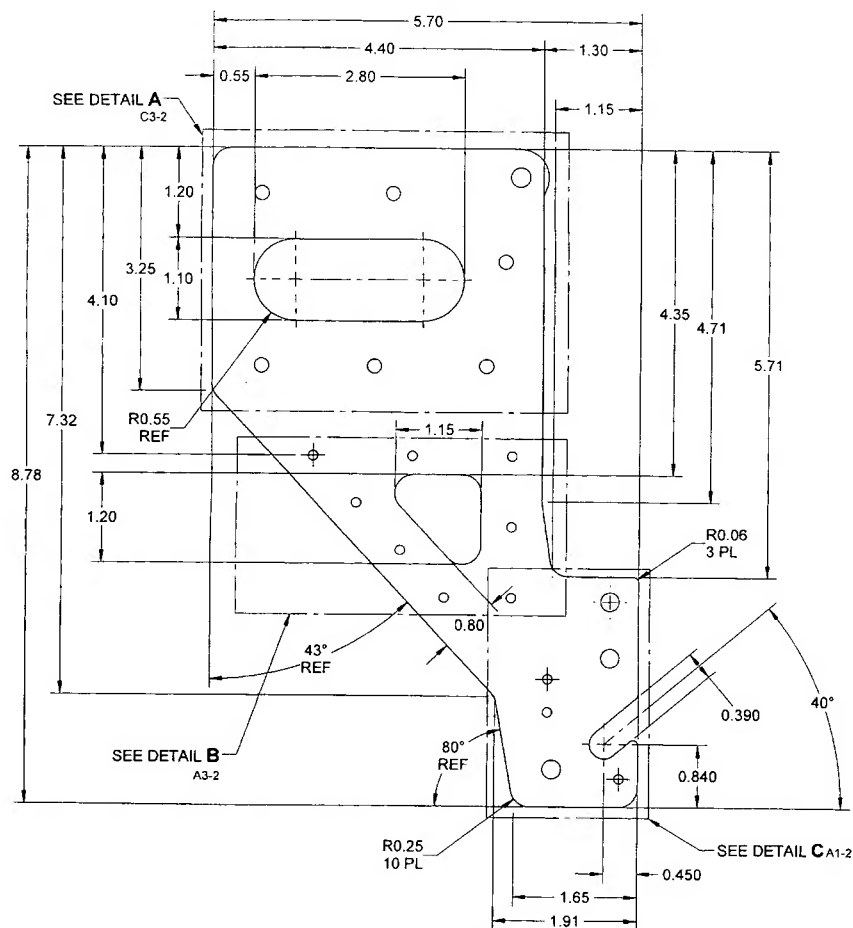
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 87313 MCT  
12/07/13

**RELEASED**  
2011-07-28  
JW

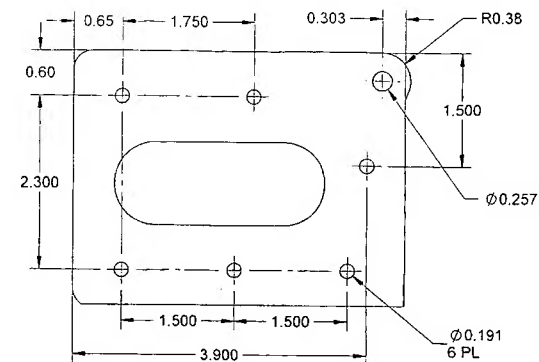
**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs  
-3: 1.10 lbs

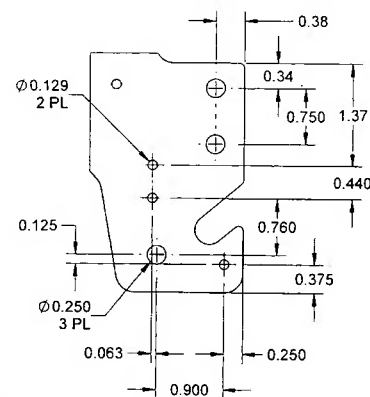
A		NEW ISSUE		AJS		11.07.06		
REV.		DESCRIPTION			BY		DATE	
DESIGN		AJS		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA				
DRAWN		AJS						
CHECKED		JP		DRAWING NO.		REV. A		
MFG. APPR.		EE		D4419		SHEET 1 OF 3		
APPROVED		JP		TITLE		SCALE		
DE APPR.		JH		BASKET SUPPORT PLATES				NTS
DATE		11.07.06		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR CONSUMER TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				



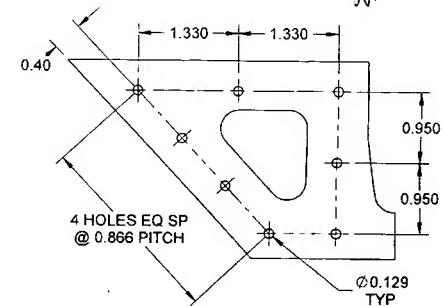
**D4419-1 FWD SUPPORT PLATE**



**DETAIL A D8-2**



**DETAIL B B7-2**

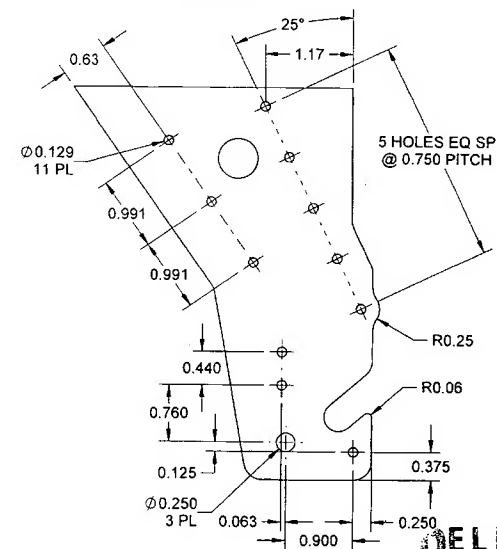
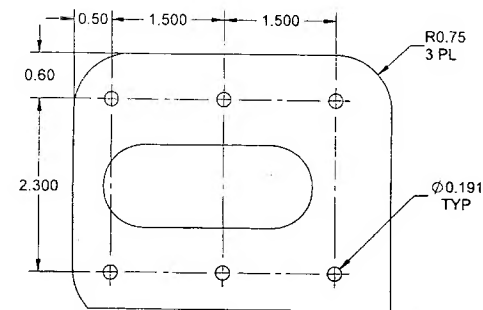
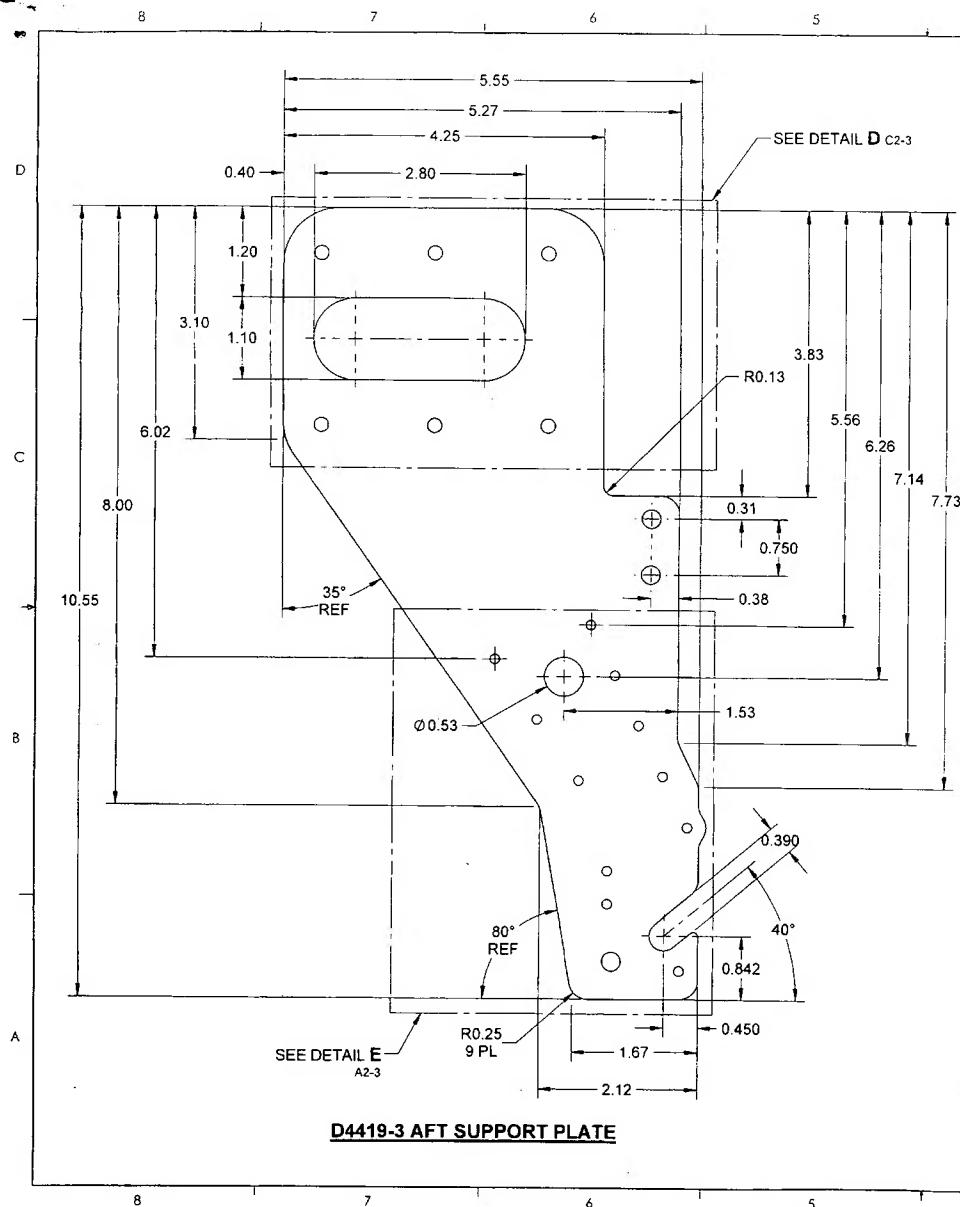


**DETAIL C A4-2**

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4419</b>	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BASKET SUPPORT PLATES</b>	NTS
DATE	11.07.06	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

**RELEASED**  
2011-07-28

87313



DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4419</b>	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BASKET SUPPORT PLATES</b>	NTS
DATE	11.07.06	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMES OR COMMUNITATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

**RELEASED**  
2011-07-08  
JAN